

ASAP! TODAY

Work Order ID 64306

Thursday, December 02, 2010 8:55:39 AM

Page 1

Item ID: D3642-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Doubler

Start Date: 12/2/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 12/9/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10/22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3642

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3642 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

2024 .050

B10-12-9

18

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-12-9

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

10 12 09 19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64306

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

18 BR 10-12-9

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

W 10/12/09

18 0

150



Packaging

Packaging

Identify as per dwg & Stock Location: 243

0.00

Memo

0.00

R 12/19 18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 64306

Page 3

Thursday, December 02, 2010 8:55:39 AM

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Setup Start



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Item Name: Doubler

Start Date: 12/2/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 12/9/2010 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/09 JJ

MF

10-12-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, December 02, 2010 8:55:44 AM

Page 1

Work Order ID: 64306

Parent Item: D3642-1

Parent Item Name: Doubler



Start Date: 12/2/2010

Required Date: 12/9/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050

Purchased

No

100

sf

97.8847

0.1664

2.101895

3.0



B10-12-9

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT22

97.8847

111381

11.89

113189

0.3947

114968

85.6

(18)

114968

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	64309
Description: Doubler		Part Number:	D3642-1
Inspection Dwg: D3642	Rev: B	Page 1 of 1	

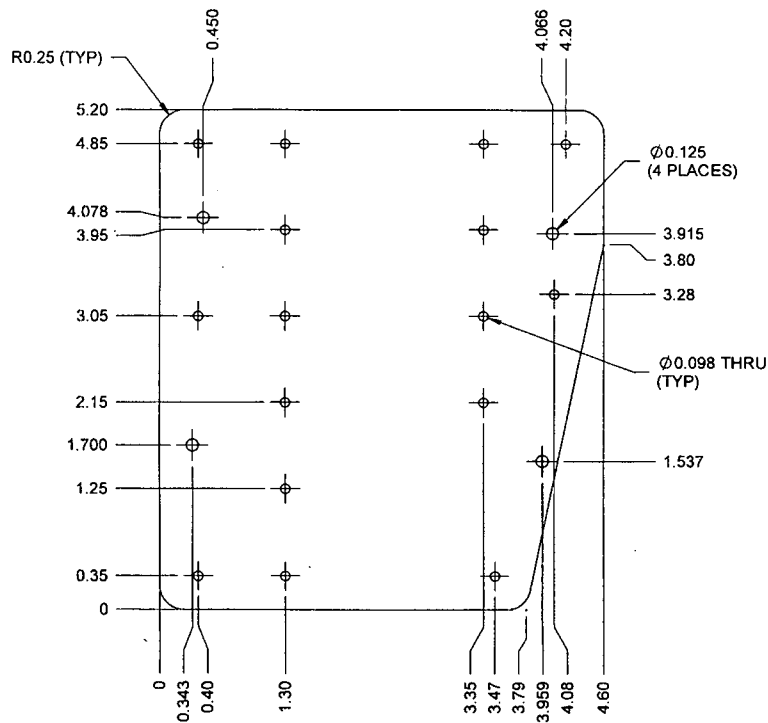
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.125	+0.004/-0.001	.128	X		✓ 1802	
Ø0.098	+0.004/-0.001	.100	X		✓	
0.35	+/-0.030	.351	X		✓	
1.25	+/-0.030	1.253	X		✓	
1.700	+/-0.010	1.702	X		✓	
2.15	+/-0.030	2.155	X		✓	
3.05	+/-0.030	3.054	X		✓	
3.95	+/-0.030	3.953	X		✓	
4.078	+/-0.010	4.079	X		✓	
4.85	+/-0.030	4.854	X		✓	
5.20	+/-0.030	5.204	X		✓	
0.343	+/-0.010	.345	X		✓	
0.40	+/-0.030	.400	X		✓	
1.30	+/-0.030	1.303	X		✓	
3.35	+/-0.030	3.350	X		✓	
3.47	+/-0.030	3.467	X		✓	
3.79	+/-0.030	3.786	X		✓	
3.959	+/-0.010	3.959	X		✓	
4.08	+/-0.030	4.084	X		✓	
4.60	+/-0.030	4.604	X		✓	
1.537	+/-0.010	1.537	X		✓	
3.28	+/-0.030	3.281	X		✓	
3.80	+/-0.030	3.80	X		✓	
3.915	+/-0.010	3.914	X		✓	
0.450	+/-0.010	.442	X		✓	
4.066	+/-0.010	4.067	X		✓	
4.20	+/-0.030	4.198	X		✓	

Measured by: RB	Audited by: M. M.	Prototype Approval:	N/A
Date: 10-12-9	Date: 10.12.09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	
B	08.12.01	Dimensions updated per Dwg Rev. B	KJ/EC	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44309
Pl 10-12-7



D3642-1 DOUBLER (WAS GENEVA P/N G10607-1/-2) \triangle B

RELEASED
01.11.14

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3642-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs

B	REMOVE -2; UPDATE -1 TO INCLUDE G10607-2	LE	07.10.16
A	NEW ISSUE; REPLACES G10607	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	UC		
CHECKED	RA		
MFG. APPR.	EC		
APPROVED			
DE APPR.			
DATE	07.10.16		

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D3642	REV. B SHEET 1 OF 1
TITLE DOUBLER	SCALE 4:5
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